

Date: Wednesday, 3/7/2007 8:38:13 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 3" OUTER TUBE
Job Number	: 31032		
Estimate Number	: 10796		
P.O. Number	: <u>N/A</u>	Part Number	: D26001190
This Issue	: 3/7/2007	Drawing Number	: D2600 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u>	Drawing Revision	: D1
Previous Run	: 24841	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 3/20/2007
Checked & Approved By	: <u>[Signature]</u> 07.03.07	Qty:	80 Um: Each
Comment	Est Rev.A 99.08.18 Was 2600-1 added -240 for length EC Est Rev.B 07.02.28 Changed length to -190 LL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	-PURCHASING
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Comment: PURCHASING

Issue P/O: 3263

a) Extrude as per Dwg D2600 (190" long)

b) Material: 6061-T6

c) Tool: MH-18870 Ben L #997121

d) Material certification is required.

2.0	D26001190P	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 Extrusion Round 3" 206

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

JB 7-8-18

Dart Aerospace Ltd.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 31032

Part Number: D26001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(82)

Comment: FINAL INSPECTION/W/O RELEASE

20769/19

Job Completion



U 07-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DRY</i>	DRAWN BY <i>DRY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>40</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

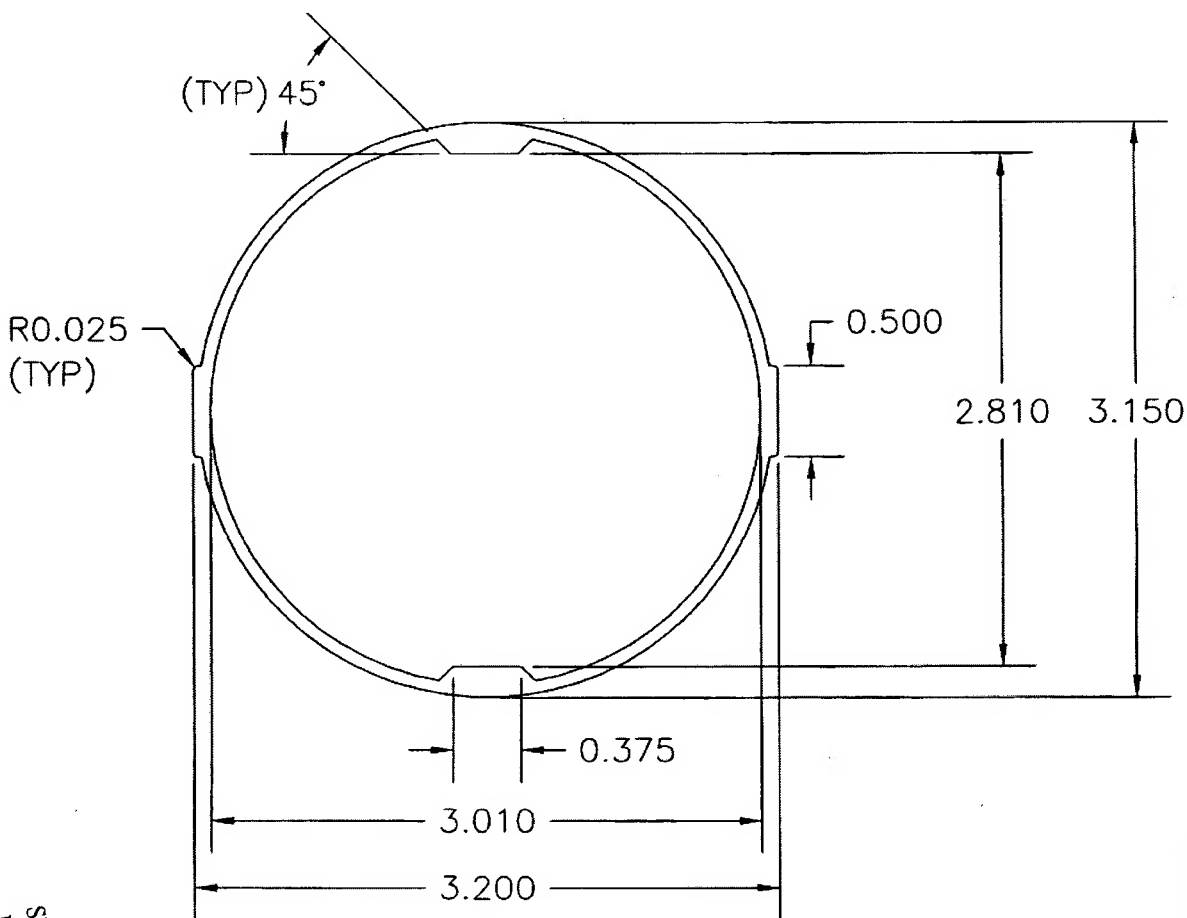
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31032

DART



DESIGN	<i>DB</i>	DRAWN BY	<i>DB</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. D
CHECKED	<i>KE</i>	APPROVED	<i>DB</i>	DRAWING NO. D2600	SHEET 2 OF 5
DATE	98.08.20	TITLE	EXTRUSION	SCALE	1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

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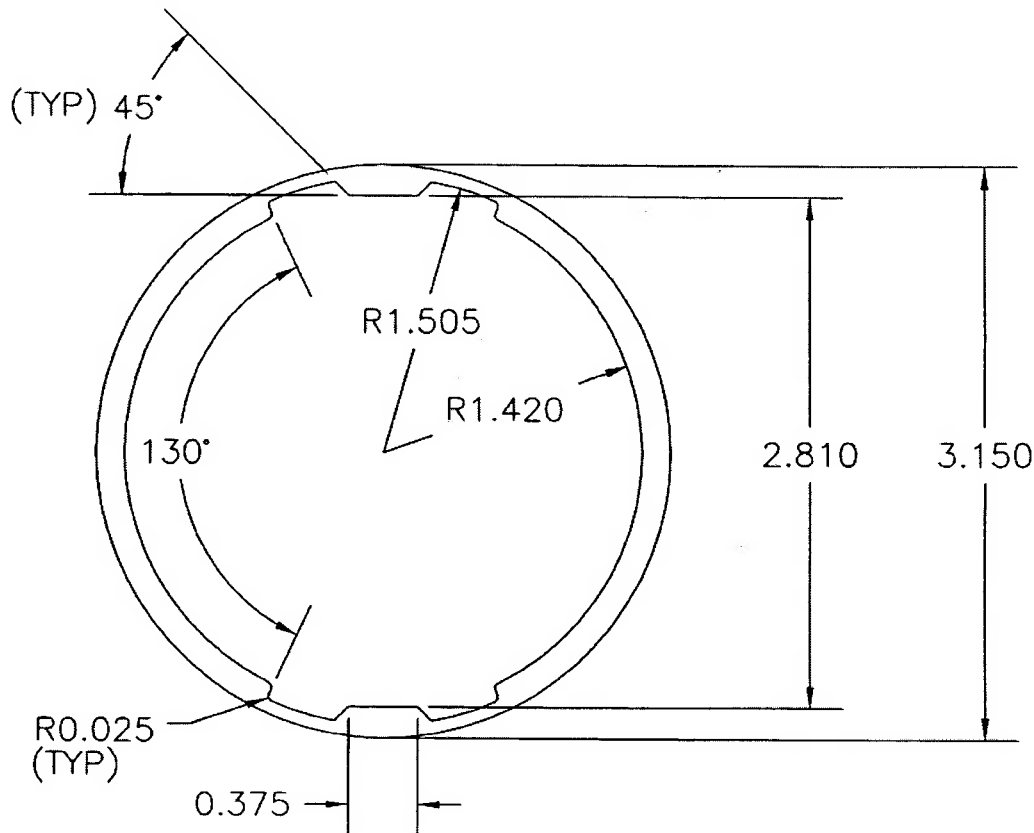


WORK ORDER
NO. 31032

DART



DESIGN	<i>me</i>	DRAWN BY	<i>me</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>KE</i>	APPROVED	<i>st</i>	DRAWING NO.	D2600
DATE	98.08.20	TITLE	EXTRUSION	REV. D	SHEET 3 OF 5
				SCALE	1:1



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



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WITHOUT NOTICE

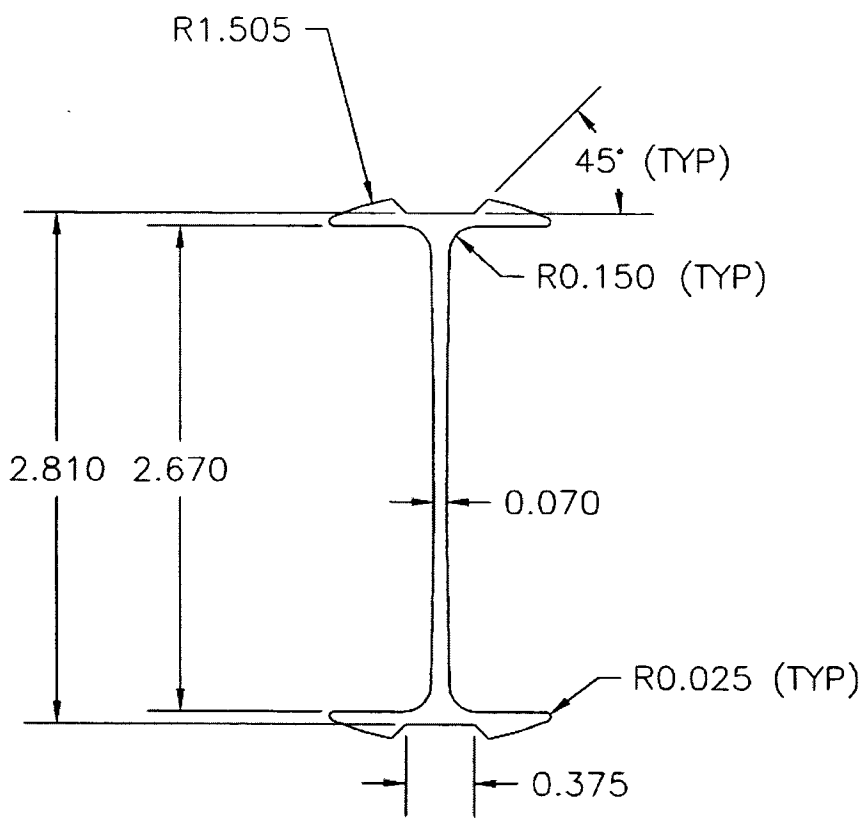
WORK ORDER
NO. 31032

RELEASED
98.8.25 DS



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION	SCALE 1:1	

RELEASED
98.8.25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

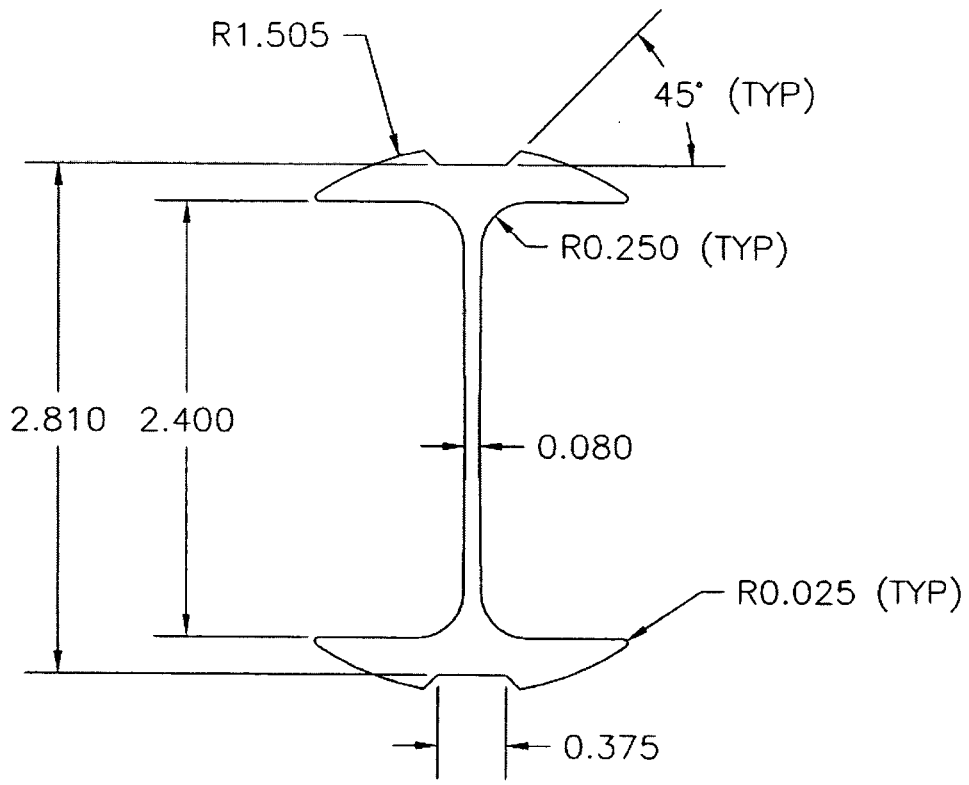


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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31032



DESIGN	DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>JS</i>	DRAWING NO. D2600	REV. 0
DATE 98.08.20		TITLE EXTRUSION	SHEET 5 OF 5
			SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



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WITHOUT NOTICE

WORK ORDER
31032

**BON L CANADA INC**

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Part Date	Part No	Sales Order	Page
08/03/07	163764	79932	1
Part ID	P/L No	Lot	Date
4249	00352652	79932010	8/03/07
Sold To	46024	Ship To	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-3	190" Mill 6061 T6	D2600-1-190
Gross Weight	656 KGS		
Net Qty	628 KG	82 PC	396 M
Specification	AMS-QQ-A-200/8 & ASTM B221-00		
	2 PKG		

Mechanical Tests:

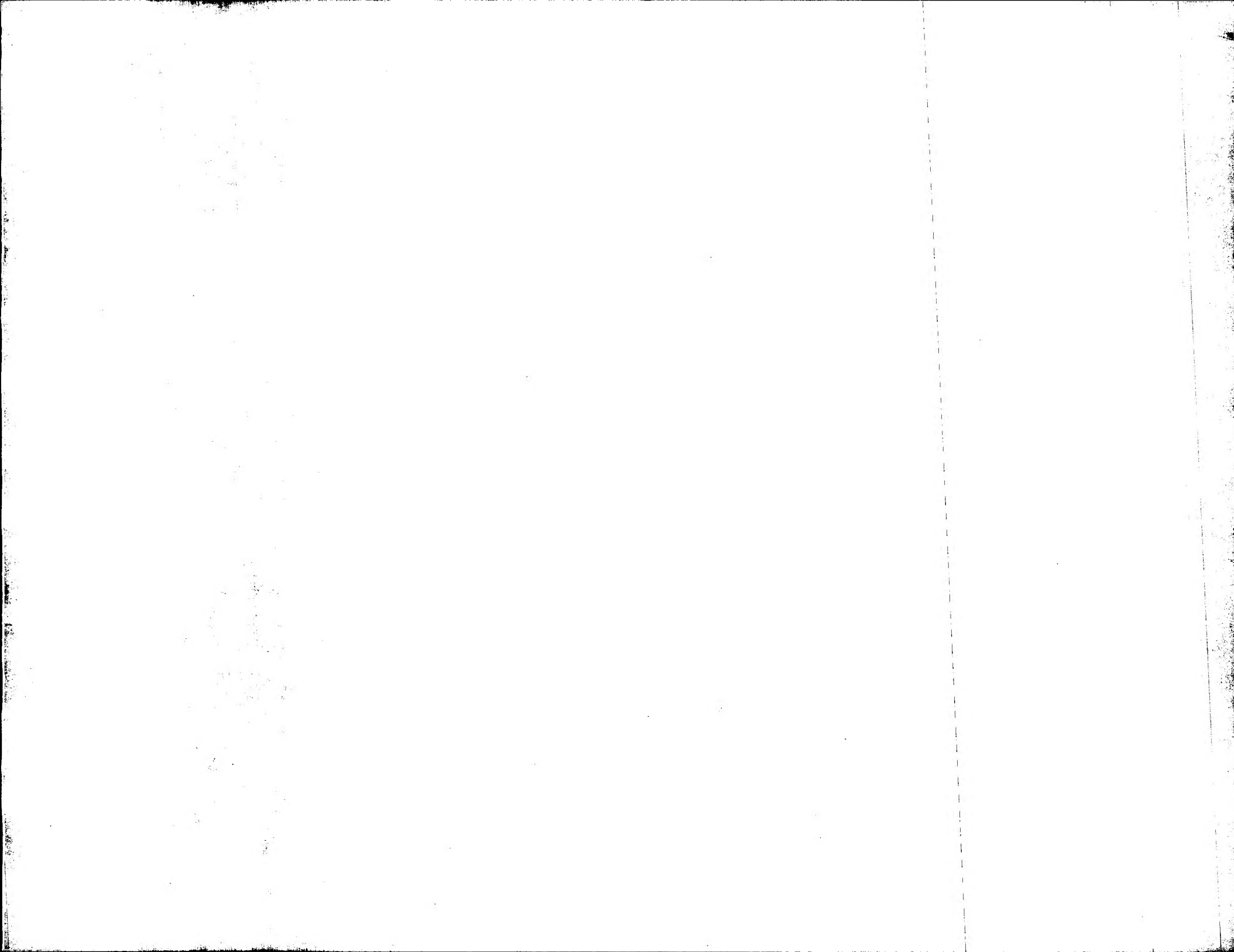
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	275.9 / 40.0	213.1 / 30.9	11.5	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada



WILLIAM L. BONNELL COMPANY, INC.
AN L MANUFACTURING COMPANY
 SUBSIDIARIES OF TREDEGAR CORPORATION
 FILIALES DE LA CORPORATION TREDEGAR

The logo for BON, featuring the word "BON" in a stylized, bold, italicized font. The letter "O" is replaced by a large, textured, three-dimensional block letter "Z" that appears to be made of a dark, possibly metallic or stone-like material. The "Z" is oriented vertically, with its top pointing towards the top right and its bottom pointing towards the bottom left, creating a sense of depth and movement. The overall style is modern and graphic.

INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

L4C 4Y9

**SHIPPING MANIFEST
BORDEREAU D'EXPEDITION**

MANIFEST DATE/DATE D'EXPÉDITION

MANIFEST NUMBER/N° D'EXPÉDITION

SALES ORDER NUMBER/N° DE COMM.

**REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.**

CREDIT REP
REP. DU CRÉDIT
HAMBROOK, PAU
905-508-3250

SALES REP
REP. DES VENTES

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

~~ACCT# 00046024~~
DIE A

SOLD TO/VENDU À

OSPACE LTD.
RDEEN ST.
RY

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

O/P

3-632-5200

PHONE 613-632-5200

RIH OTTAWA

59358

ENT	ORDER DATE	CUST. P.O. NO./N° DE COMM. DU CLIENT	JOB/PROJET
-----	------------	--------------------------------------	------------

BILL OF LADING NUMBER/N° DE CONNAISSEMENT

07/25/07 4249

00352652

QUANTITY QANTITE	UNIT UNITE	PREVIOUS SHIPPED QTY QTE DEJA EXPEDIEE	MFG PART NUMBER N° DE PIECE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPER	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITE	QUANTITY DUE QUANTITÉ PRÉVUE
			CUSTOMER PART NUMBER NUMÉRO DE PIÈCE DU CLIENT	LENGTH LONGUEUR	FABRICATION DESCRIPTION TYPE DE FABRICATION	NO PKGS N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
				CUTTING TOLERANCE TOLÉRANCE DE COUPE	SHIPPING TOLERANCE TOLÉRANCE D'EXPÉDITION					
80	KG	0	DAA-897121-3	6061 /TG	MILL	2	656	628	KG	0
	M	0	D2600-1-190	190"	CERTIFICATE OF COMP			395.73	M	0
	PC	0		+5/16 "	(+015-015,0092-0068)			82	PC	0
				-0 "						
				DETAIL; LOT/TICKET	79932010 / 174557	1	411	395		51 PC
					79932010 / 174559	1	245	233		31 PC
						2	656	628	KG	
								395.73	M	

S WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
 ATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER
CLIENT

70001
Cert No: 163764

Certificate of Compliance

Page - 1
Date - 8/27/07

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date. . . 08/03/07

Sales Order. . . 79932
Cust PO. . . 4249
E/L No. . . 00382652
Lot. . . 79932010

Sold to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Ship to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

Item Number	Part Number	Item Description	Gross KGS	Net Quantity
1.000	DAA-897121-3	190" Mill 6061 T6	656	628 KG 82 PC 396 M 2 PKG

Cust part: D2600-1-190
Specification: AMS-QQ-A-200/8 & ASTM B221-00

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	324.9 / 47.1	286.9 / 41.6	10.4	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	CA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

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